Work Order ID 97712 Page 1 February-21-13 12:41:21 PM Item ID: D3020-1 Accept *N900040100* Setup Start **Revision ID:** Stop Fitting Item Name: *12* **Start Oty: 12.00 Start Date:** 2/21/13 **Cust Item ID:** Required Date: 2/28/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: MUJ Date: 13-02-2/Tooling: Date: **Approvals:** Stop Date: SPC (Y/N): Date: Sequence ID/ Reject Set Up/ Tool ID Tool # Plan Reject Insp. **Operation** Accept Qty Work Center ID Description **Run Hours** Code **Qty** Number Stamp **Draw Nbr Revision Nbr** D3020 Rev A 100 0.00 Hardinge CNC LATHE SMALL 12 8 *100* 0.00 Hardinge 13/03/01 Memo Turn blank as per Folio FA255 and Dwg D3020 Hardinge CNC Lathe Small 110 QC2-Inspect parts off machine FAI/FAIB 0.00 12 0 *110* 13/03/01 QC 0.00 Memo Quality Control 120 0.00 13.3.L Small Fab *120* Small Fab 4. 0.00 Memo Small Fab

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		Cuffs			İ	Contamination	1	Mainte	nance	į		Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Work Orde February-21-13				*977		Page 2				
Item ID: Revision ID: Item Name:	D3020-1 Fitting			Accept	*N90004	01 00)* 5	Setup Star Stop	14.	S1* S2*
Start Date: Required Date: Reference:	2/21/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item ID: Customer:				IV	17
Approvals:		lan:			Date:		J	Run Star Stop	"1711	₹1* ₹2*
Sequence ID/ Work Center I 130 *130* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	Tool ID Tool	l# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp OAS 04 8-69
140 *140* Packaging Packaging	, .	Identify as per dwg & Sto Packaging Memo	ock Location	0.00			12 x			-SP 3-3-
150 *150* oc		QC21- Final Inspection -	Work Order Release	0.00				MLJ	130	3-06

NB-03-4

											DQA:	Date:	
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						· · · · ·					QA Closed:	Date:	
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Part N	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No					Work Order Update	ا ل		Large Fab	Composite		Supplier	
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Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge Other
Ripples in Bend	Drill Holes	Offset	
Torque Waves in Extrusion	Drawing	Out of Calibration	
Turning Sequence	Finish	Out of Sequence	$\mathcal{J}_{n,n}^{\mathcal{J}}$
Wave/Twist in Tube	Folio	Outside Dimensions	4 7 3

Hardware

Maintenance

Mislabeled

Inspection Incomplete

Instructions Incomplete/Unclear

Over/Under tolerance

Part Incorrect

Part Moved
Positioned Wrong

Part Lost/Missing

Temperature/Cure

Wrong Stock Pulled

Weld

BOM/Route

Contamination

Countersink

Burrs

Broken/Damaged

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Centre Not Concentric to O/S

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

February-21-13 12:41:21 PM

Work Order ID:

97712

Parent Item:

D3020-1

Parent Item Name:

Fitting

Start Date: 2/21/13

Required Date: 2/28/13

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP B03.05.06Reformat; Made on CobraKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1018R1.250 1018 ROUND BAR 1.250		Purchased	No			100	f	29.8190	0.0879	1.1103156	90	13/03	101

											DQA:	Date:	<u> </u>
NCR:	⁄es	/ No				WORK ORDER NON-C	100	VFORI	MANCE / UPI	DATE			
											QA Closed:	Date:	
Work Orde	 .					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	=1					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
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Root			_	_	1	ption of work order update		Initial		tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
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Equip/Tooling				Ì.									
Operator	Ш												
Material	Ш												
Setup	Ш												
Other	Щ												
Process	Ш			·									
Supplier	Ш										[
Training	Ш		•										
Unapproved	Ш		<u> </u>		L	_	1	T 0475					
							AUI	LT CATE	GORY				
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	ш	Bending				Bend	\vdash	Grain		-	Ovalized		Pressure/Forced
	Н	Centre No	ot Concer	ntric to	o/s	BOM/Route	-	Hardwa		ļ-	Over/Under	<u> </u>	Temperature/Cure
	-	Cracks			<u> </u>	Broken/Damaged	-	4	ion incomplete	├-	Part Incorre	⊢	Weld
	$\boldsymbol{\vdash}$	Crushed/	Crimped.		<u> </u>	Burrs	-	4	tions Incomplete/	Unclear	Part Lost/M	_	Wrong Stock Pulled
	├	Cuffs			<u> </u>	Contamination	<u> </u>	Mainte		_	Part Moved		
ĺ	1 I	Heat Trea	it		1	Countersink	1	Mislabe	eled	Į.	Positioned \	wrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	97712
Description: Fitting	Part Number:	D3020-1
,		
Inspection Dwg: D3020 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension		-	Inspection	
1.25	+/-0.010	1,242			VERN	PAD-01
0.030 x 45°	+/-0.010	· 030	V		u	, κ
0.640	+0.000/-0.010	-637			ц	24
0.930	+/-0.010	. 937	/		H	И
0.125	+/-0.010	, 128	/		u	ч
0.300	+/-0.010	. 299	/		u	•
0.844	+/-0.010	850	V.		şt	•4
1.030	+/-0.010	1,030			Ęţ	64
Ø0.750	+0.005/-0.000	. 751	/		16	u
0.200	+/-0.010	. 201			if	16
				 		
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Measured by:	Po	Audited by:	04	Pro	totype Approval:	N/A
Date:	(3/03/0)	Date:	13.3.		Date:	N/A

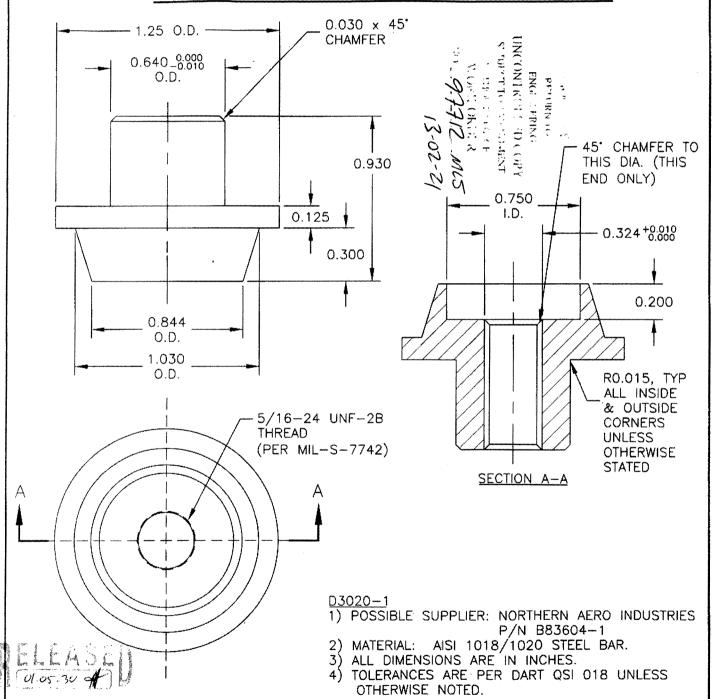
Rev	Date	Change	Revised by	Approx/ed
Α	05.04.26	New Issue	KJ/JLM	
				





)	DESIGN ()	DRAWN BY		OSPACE LTD ONTARIO, CANADA
	CHECKED /	APPROVED	DRAWING NO.	REV. A
	#	1 d	D3020	SHEET 1 OF 1
	DATE		TITLE	SCALE
	01.05.18		FITTING	2:1
	Α	01.05.18	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



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